

Work Order ID 44565 - 2

July 2, 2009 7:25:19 AM



split

Page 1

Item ID: D3023-1

GY

Accept



Setup Start



Revision ID: A

Item Name: Back Panel

Stop



Start Date: 7/15/09 Start Qty: 2.00



Cust Item ID:

Required Date: 8/03/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3023

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3023

Dwg Rev: _____

Prog Rev: _____

***graind direction along 28.100" ***

2-Deburr if necessary



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control



Work Order ID 44565

July 2, 2009 7:25:19 AM



Page 2

Item ID: D3023-1

Revision ID: A

Item Name: Back Panel

Start Date: 7/15/09

Start Qty: 2.00

Required Date: 8/03/09

Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

130



Brake NC

Brake NC

NC BRAKE

0.00

Memo

0.00

1-Bend as per Dwg D3023 2-form edge of back pan as per dwg D3023 using
D3017-041 back frame

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Work Order ID 44565

July 2, 2009 7:25:19 AM



Page 3

Item ID: D3023-1

Revision ID: A

Item Name: Back Panel

Start Date: 7/15/09 Start Qty: 2.00

Required Date: 8/03/09 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

MS 09-07-01 (X)

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

7:30am

OVEN TEMPERATURE:

8:00am FINISH TIME:

320°F

11109091 09-07-06 (1) A

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 09-07-06 (1)

Work Order ID 44565

July 2, 2009 7:25:19 AM



Page 4

Item ID: D3023-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Back Panel

Start Date: 7/15/09 Start Qty: 2.00



Cust Item ID:

Required Date: 8/03/09 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Identify as per dwg & Stock Location:

Store

0.00



Packaging

Memo

0.00

Packaging

9/14/06

50

(Signature)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/07

W 09.57-07

Picklist Print

July 2, 2009 7:25:18 AM

Page 1

Work Order ID: 44565

Parent Item: D3023-1RevA

Parent Item Name: Back Panel

Comments:



Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	111.0100	6.0583			



2024-T3 .032 sheet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	111.01	
102942	1.5	
105555	5	
106272	8.47	
108595	3	
109240	7.02	
110778	34.02	
111699	49	
18147	3	

*Date: Monday, 12/01/2009 2:30:34 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BACK PANEL
Job Number	: 44565 <i>2</i>	Part Number	: D30231
Estimate Number	: 11093	Drawing Number	: D3023 REV A
P.O. Number	:	Project Number	: N/A
This Issue	: 12/01/2009 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: 1/1 Type : LARGE FAB ASSY	Due Date	: 10/02/2009
Previous Run	: 44564	Qty:	<i>split</i> 1 Um: Each
Written By	:		
Checked & Approved By	: <i>JUD 09 01 12</i>		
Comment	: Est. C 02.01.23 Revised NG Est Rev:D 08-04-16 now water jet DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S032	2024-T3 .032 sheet
-----	-------------	--------------------



Comment: Qty.: 3.0216 sf(s)/Unit Total : 3.0216 sf(s)
2024-T3 .032 sheet
Material: 2024-T3 sheet (QQ-A-250/4) 0.032"
Batch: *110778* *B9-2-10*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D3023
Dwg Rev: *1* *B 9-2-10*
Prog Rev: *1*
****graind direction along 28.100" ****
2-Deburr if necessary *B 9-2-10*

(2)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

509/02/10 (X2)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Bend as per Dwg D3023

509/02/25

(2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:30:34 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK PANEL

Job Number: 44565

Part Number: D30231

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-form edge of back pan as per dwg D3023 using D3017-041 back frame

EL 9-6-22 (1)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

50767.1 (2)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>W4565</u>
Description: Back Panel		Part Number: D3023-1
Inspection Dwg: D3023	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

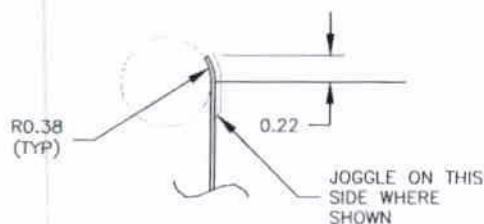
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.129	X			
Ø0.191	+0.005/-0.001	.196	✓			
1.660	+/-0.010	1.658	✓			
0.375	+/-0.010	.374	X			
1.340	+/-0.010	1.336	✓			
2.375	+/-0.010	2.375	X			
0.375	+/-0.010	.373	✓			
25.28	+/-0.030	25.28	✓			
27.03	+/-0.030	27.03	X			
28.10	+/-0.030	28.10	✓			
1.30	+/-0.030	1.292	✓			
2.375	+/-0.010	2.374	X			
8.711	+/-0.010	8.712	✓			
5.597	+/-0.010	5.595	✓			
8.57	+/-0.030	8.57	✓			
1.970	+/-0.010	1.973	✓			
7.42	+/-0.030	7.420	✓			
10.92	+/-0.030	10.920	✓			
14.75	+/-0.030	14.75	✓			

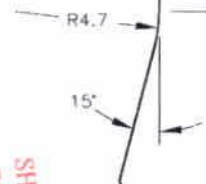
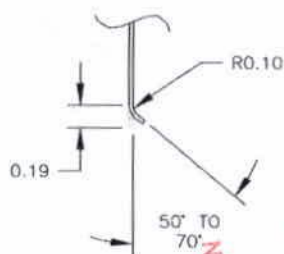
Measured by: <u>RB</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>9-2-10</u>	Date: <u>09/02/10</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC <u>AF</u>	<u>DD</u>

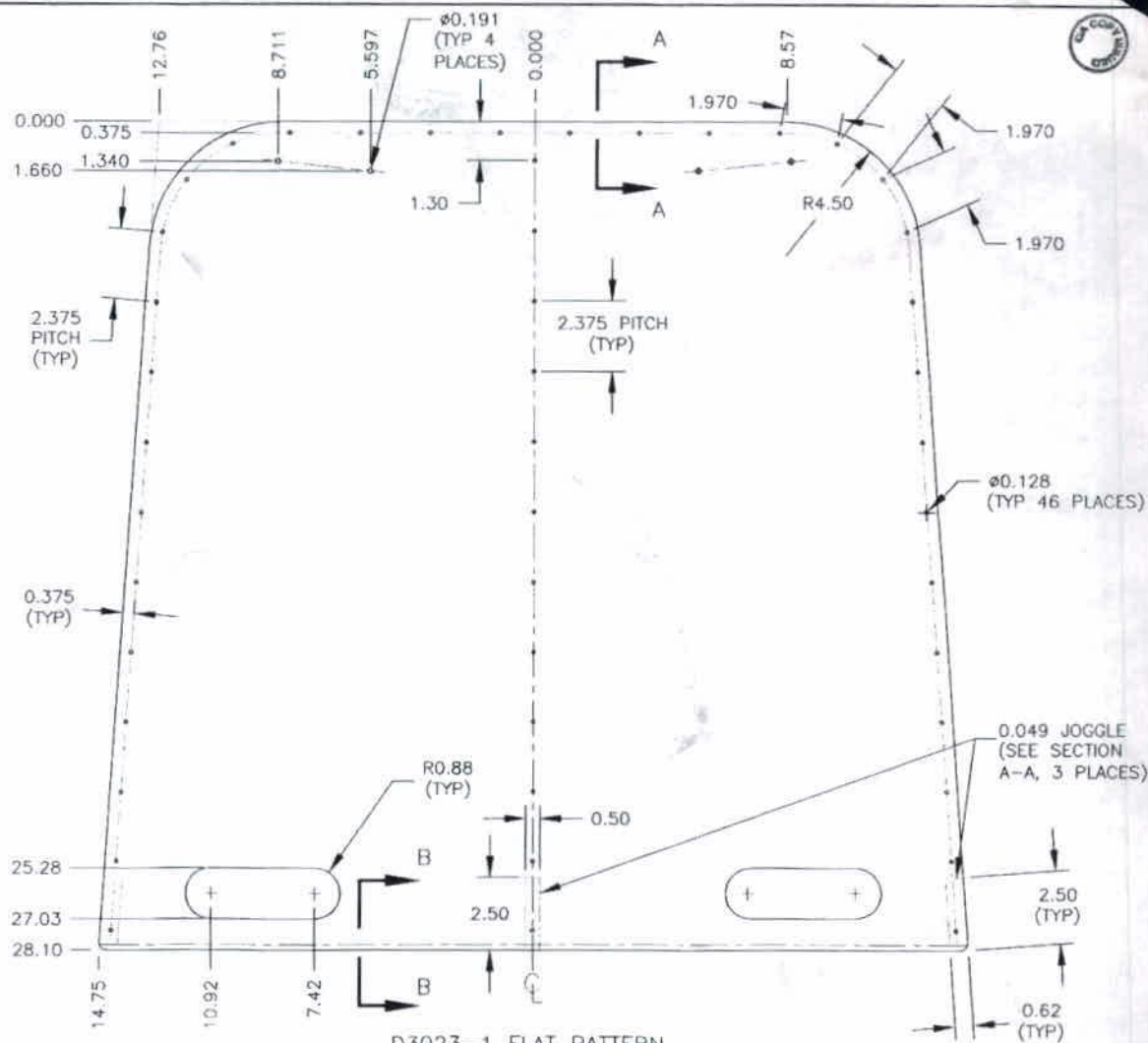
SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)



SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)



D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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A	01.05.18	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. WARRICKSLEY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3023
DATE	01.05.18	TITLE BACK PANEL
		REV. A SHEET 1 OF 1 SCALE 1:4